

Date: Wednesday, 5/23/2007 3:24:41 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DOUBLER
Job Number : 32473
Estimate Number : 12105
P.O. Number : N/A Part Number : D32011
This Issue : 5/23/2007 S.O. No. : N/A Drawing Number : D3201 REV B
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB Drawing Revision : B
Previous Run : 30827 Material : N/A
Due Date : 6/6/2007 Qty: 20 Um: Each
Written By :
Checked & Approved By : Johnston, Kim
Comment : Est Rev:A Removed from 9 Digit 06-01-25 JLM
Est Rev:B Now on Waterjet 06-08-14 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S040 2024-T3 .040 sheet



Comment: Qty.: 0.2898 sf(s)/Unit Total : 5.7960 sf(s)
Material: 2024-T3 (QQ-A-250/4) 0.040" thick
(M2024T3S.040)
Identify for D3201-1
Batch: M103039

SAD 07/06/06

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3201
Dwg Rev: B
Prog Rev: B

2-Deburr if necessary

SAD 07/06/06

22

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD

07/06/06

22

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

MS

07/06/06

22

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack

John 07/06/11 (22)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 27/06/14

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: DOUBLER

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MF

07-06-12

22

~~SB @ 10/6/11~~ 22

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC 7/6/13

22

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 80

PC 7/4/13

22

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2707/06/14

22

Job Completion



u 07-06-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

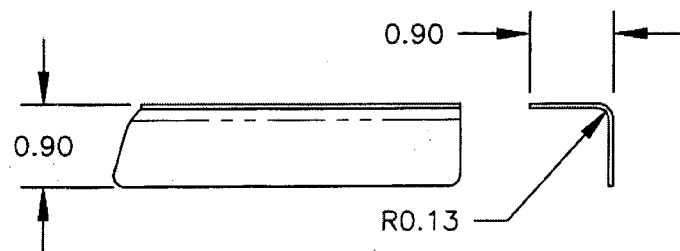
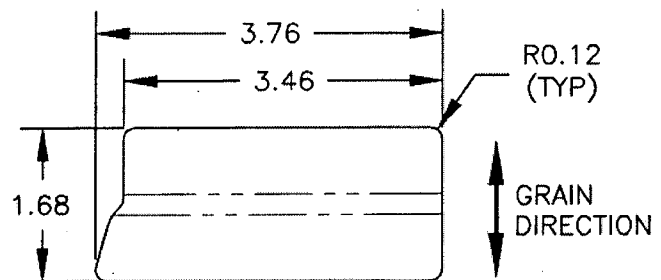
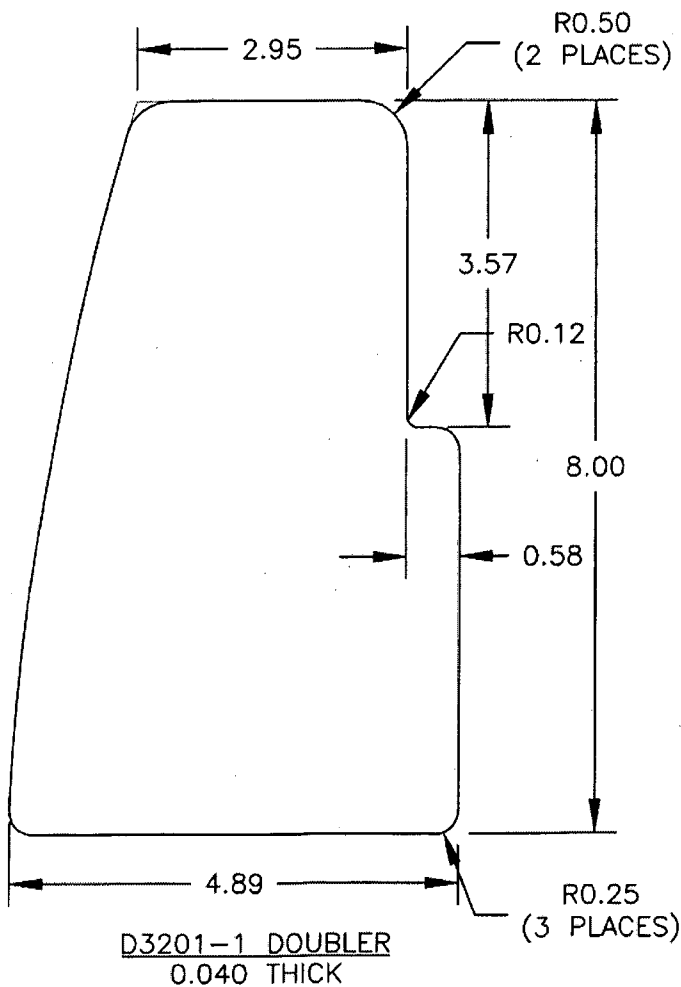
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3201	REV. B SHEET 1 OF 1
DATE 03.11.03		TITLE DOUBLER	SCALE 1:2
A	03.08.07	NEW ISSUE	
B	03.11.03	MODIFY D3201-1, ADD D3201-3/-4	

RELEASED
03.11.14**D3201-1/-3/-4 DOUBLER**

- 1) MACHINE PARTS PER DWG FILE "D3201-B1.DWG"
- 2) MATERIAL: 2024-T3 ALUMINUM SHEET (QQ-A-250/4)
(REF. DART SPEC M2024T3S)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32473

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